



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D120-638-011
Job Sheet 191746



Part No: D120-638-011

Job Qty: 1 pcs

Part Name: EC120 Bearpaws



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/7/19

Job Tracking No:

Due Date: 3/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E1 IPP Rev:A New Issue 07-01-02 JLM IPP Rev:B Added Step 2 08-04-16 JLM Verified By:EC IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
160	Packaging 1 - Pick Kit	1 pcs	3/8/19	3/8/19	0.00	0.00	Packaging 1 - 1		MAR 07 2019
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

Plex 3/7/19 12:53 PM Dart.lajeunesse.marie

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
170 QC 4	1 pcs	3/8/19	0.00 0.00		QC 4 - 26	
					QC 4 - 28	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 6	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
175 DC - 1 - B4B	1 pcs	3/8/19	0.00 0.00		DC - 1 - B4B	DAS 46 MAR 08 2019
					DC - 2 - B4B	21 9-89 MAR 08 2019
180 Packaging 3-1 - Stock - B4B	1 pcs	3/8/19	0.00 0.00		Packaging 3 - 1 - B4B	DAS 46 MAR 08 2019
					Packaging 3 - 2 - B4B	9-89
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190 QC 21 - FG	1 pcs	3/8/19	0.00 0.00		QC 21 - FG - 21	DAS 21 MAR 08 2019
					QC 21 - FG - 70	9-89
					QC 21 - SA - 53	

Part Op 170 - (QC4- 100% Inspect kits for completeness)

Descriptions: 175 - Photocopy bluefile and create labels per PPP D120-638-011 CHG 002

180 - (Identify as per dwg & Stock Location: _____), Identify and pack for shipping as per PPPD120-638-011

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-15A	Bolt	8 Ea (8 ea)	160-Packaging 1 - Pick Kit	5134436
D2182B050	Clamp Cushion Black 5.0 " Long	4 pcs (4 ea)	160-Packaging 1 - Pick Kit	5149395
D2274	Radius Block	8 pcs (8 ea)	160-Packaging 1 - Pick Kit	5155948
D2435	Bearpaw	2 pcs (2 ea)	160-Packaging 1 - Pick Kit	5145984
D2438	Clamp	4 pcs (4 ea)	160-Packaging 1 - Pick Kit	5136884
D2529	Washer	8 pcs (8 ea)	160-Packaging 1 - Pick Kit	5148345
MS21042L4	Nut	8 Ea (8 ea)	160-Packaging 1 - Pick Kit	5149814
NAS1149D0463J	Washer	8 Ea (8 ea)	160-Packaging 1 - Pick Kit	5150216

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
160-Packaging 1 - Pick Kit	AN4-15A	8	354	0
	D2182B050	4	74	0
	D2274	8	307	0
	D2435	2	3	0
	D2438	4	91	0
	D2529	8	575	0
	MS21042L4	8	3,698	0
	NAS1149D0463J	8	7,437	0

Part Specifications



Container No: S160592



Part: D120-638-011

Job No: 191746

Serial No/Batch: S160592

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH99-221 Issue 1, FAA STC SR01177

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

e found.

Plex 3/7/19 12:53 PM Dart.lajeunesse.marie

Entered: _____ Date: _____

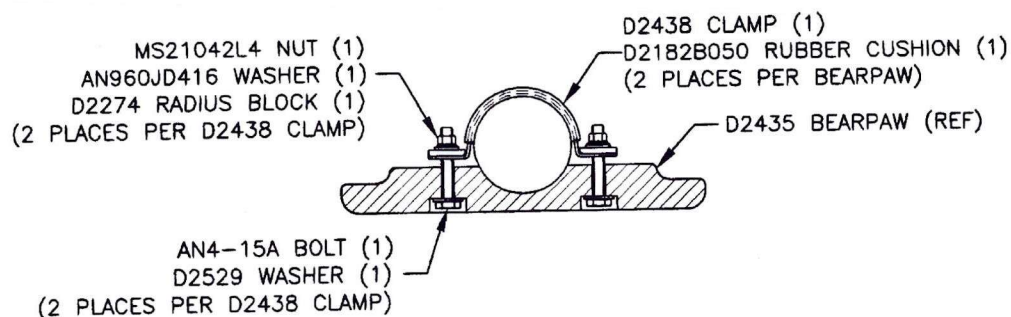


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

*Figure 2 – Bearpaw Installation*

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D120-638-011 Bearpaw	8.4 lb 3.82 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.7 in 4.54 m	1501.1 in-lb 17.34 m-kg

5. PARTS LIST

Qty	Part Number	Description
X	D120-638-011	BEARPAW INSTALLATION
4	D2182B050	Rubber Cushion
8	D2274	Radius Block
8	D2529	Washer
2	D2435	Bearpaw
4	D2438	Clamp
8	AN4-15A	Bolt
8	AN960JD416	Washers
8	MS21042L4	Nut (or MS21042-4)